

Work Order ID 67580

Monday, March 28, 2011 11:36:28 AM



Page 1

Item ID: D3219-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 3/28/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-03-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3219

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3219

Dwg Rev: A

Prog Rev: A

HB11-3-31

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB11-3-31

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

HB11-3-31

count

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr if necessary.

⇒ m-h

52x

11/03/31

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 ulos/31

Counter
52

150

0.00



Packaging

Identify as per dwg & Stock Location: WPA

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

P 11.03.31

52 / 0

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Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 4/04/01

MF
11-04-01

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Picklist Print

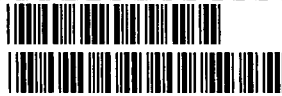
Monday, March 28, 2011 11:36:34 AM

Page 1

Work Order ID: 67580

Parent Item: D3219-1

Parent Item Name: Plate





Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 04.04.19 New issue KJ/JLM
ESR B 06.05.25 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			100	sf	154.0000	0.0964	4.058947		S. 1	
											B 11-3-31		

6061-T6 .125 Sheet

Location	Loc Qty	Loc Code
MAT021	154	
113608	130	
116700	24	

113608

52

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DART AEROSPACE LTD		Work Order: 67580
Description: Plate		Part Number: D3219-1
Inspection Dwg: D3219	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	.317	>		V 1802	
2.293	+/-0.005	2.295	x		V	
2.965	+/-0.010	2.968	x		V	
0.566	+/-0.010	.568	x		V	
0.375	+/-0.010	.376	x		V	
R0.125	+/-0.010	.125	x		R. G.	
13.9°	+/-0.5°	13.9°	>			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-3-31	Date: 11/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	
B	07.09.06	13.9° dimension added	KJ/JLM	
C	08.04.15	0.125 dimension removed	KJ/DD	

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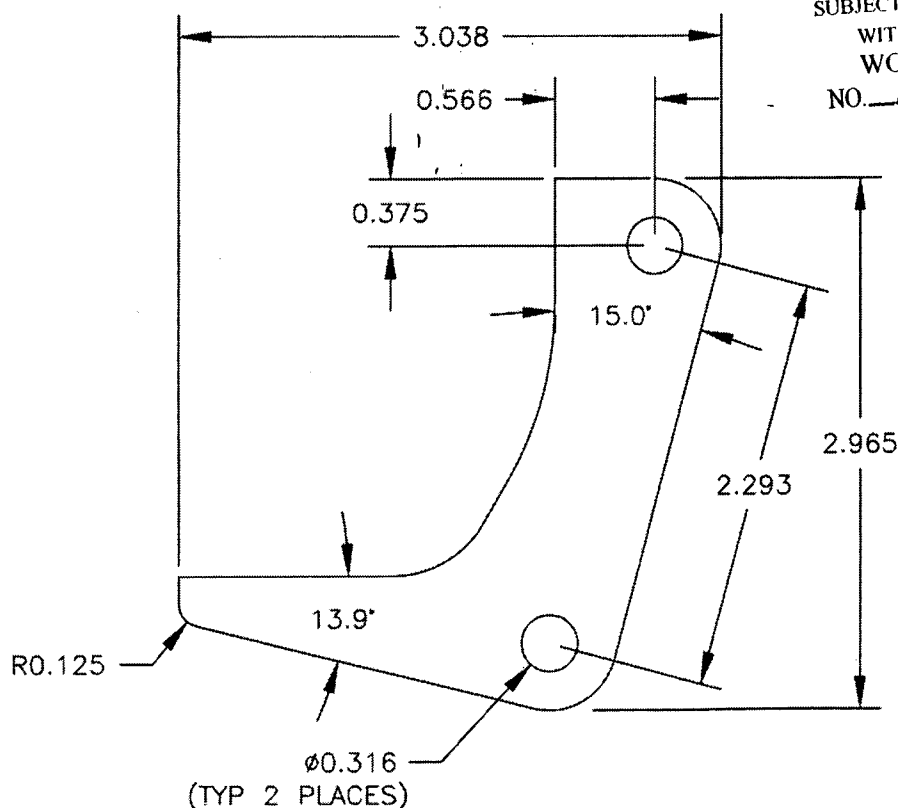


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3219	REV. A SHEET 1 OF 1
DATE 03.10.10		TITLE PLATE	SCALE 1:1
A	03.10.10	NEW ISSUE	

RELEASED
04.04.05 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67580

PL 11 03-25



D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
(REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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